

Date: Wednesday, 8/6/2008 2:40:27 PM  
 User: Chantal Lavoie

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services				Drawing Name	: BRACKET		
Job Number	: 40908				Part Number	: D33048		
Estimate Number	: 11111				Drawing Number	: D3304 REV B		
P.O. Number	:				Project Number	: N/A		
This Issue	: 8/6/2008 S.O. No. :				Drawing Revision	: B		
Prsht Rev.	: NC				Material	:		
First Issue	: / / Type : SMALL /MED FAB				Due Date	: 8/13/2008 Qty: 16 Um: Each		
Previous Run	: 40908							
Written By	<u>CL</u>							
Checked & Approved By	<u>CL</u>							
Comment	: Est A 04.09.07 New issue KJ/JLM Est B 08.08.06 waterjet EC verified by: DD							

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M304S20GA	304/316 .040 Sheet
		Comment: Qty.: 0.0683 sf(s)/Unit Total : 1.0920 sf(s) 304/316 .040 Sheet batch: <u>108118</u> <u>FB 8-8-8</u>
2.0	WATER JET	FLOW WATER JET
		Comment: FLOW WATER JET 1-Cut as per Dwg D3304 Dwg Rev: <u>B</u> <u>FB 8-8-8</u> Prog Rev: <u>B</u> <u>18</u>
		2-Deburr if necessary <u>8-8-12</u> <u>JP</u>
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
		<u>FB 8-8-8</u>
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE
4.0	QC8	SECOND CHECK
		<u>S 08/08/12 (10)</u>
		Comment: SECOND CHECK
5.0	BRAKE NC	NC BRAKE
		Comment: NC BRAKE
		1-Form as per Dwg D3304
		<u>BB 08/08/25</u> <u>18</u>

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User: Chantal Lavoie

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET

Job Number: 40908

Part Number: D33048

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC5

INSPECT WORK TO CURRENT STEP



5/08/08(25)(+18)

Comment: INSPECT WORK TO CURRENT STEP

7.0 PACKAGING 1

PACKAGING RESOURCE #1



(18)

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 83

8/8/25

SL

8.0 QC21

FINAL INSPECTION/W/O RELEASE



08/08/25(25)

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



U 08.08.25

Date: Friday, 01/08/2008 10:43:17 AM  
 User: Julie Lecocq

## Process Sheet

<b>Customer</b>	: CU-DAR001 Dart Helicopters Services			<b>Drawing Name</b>	: BRACKET		
<b>Job Number</b>	: 40908			<b>Part Number</b>	: D33048		
<b>Estimate Number</b>	: 11111			<b>Drawing Number</b>	: D3304 REV B		
<b>P.O. Number</b>	:			<b>Project Number</b>	: N/A		
<b>This Issue</b>	: 01/08/2008	<b>S.O. No.</b>	:	<b>Drawing Revision</b>	: B		
<b>Prsht Rev.</b>	: NC			<b>Material</b>	:		
<b>First Issue</b>	: / /	<b>Type</b>	: PURCHASED PARTS	<b>Due Date</b>	: 14/08/2008	<b>Qty:</b>	16
<b>Previous Run</b>	: 25157			<b>Um:</b>	Each		
<b>Written By</b>	:			<b>Comment</b>	: Est A 04.09.07 New issue KJ/JLM		
<b>Checked &amp; Approved By</b>	: JUD 08.8.05						

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	PG	PURCHASING
		 <b>Comment:</b> PURCHASING Issue P/O: _____ Email or Ship DXF file to vendor Laser Cut flat pattern per Dwg D3304(SAME AS -7) Possible Supplier: GFI & Industrial Laser Material release note is required
2.0	D33048F	BRACKET -FLAT
		 <b>Comment:</b> Qty.: 1.0000 Each(s)/Unit Total : 16.0000 Each(s) Bracket
3.0	PACKAGING 1	PACKAGING RESOURCE #1
		 <b>Comment:</b> PACKAGING RESOURCE #1 Receive & Inspect for Transit Damage Ensure Material Release Note is attached
4.0	QC6	DIMENSIONAL CHECK
		 <b>Comment:</b> DIMENSIONAL CHECK
5.0	SMALL FAB 1/	SMALL & MEDIUM FAB RESOURCE 1
		 <b>Comment:</b> SMALL & MEDIUM FAB RESOURCE 1 Deburr

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 01/08/2008 10:43:17 AM  
User: Julie Lecocq

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET

Job Number: 40908

Part Number: D33048

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 BRAKE NC NC BRAKE



Comment: NC BRAKE

1-Deburr

2-Form as per Dwg D3304

7.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

8.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

9.0 QC21 FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

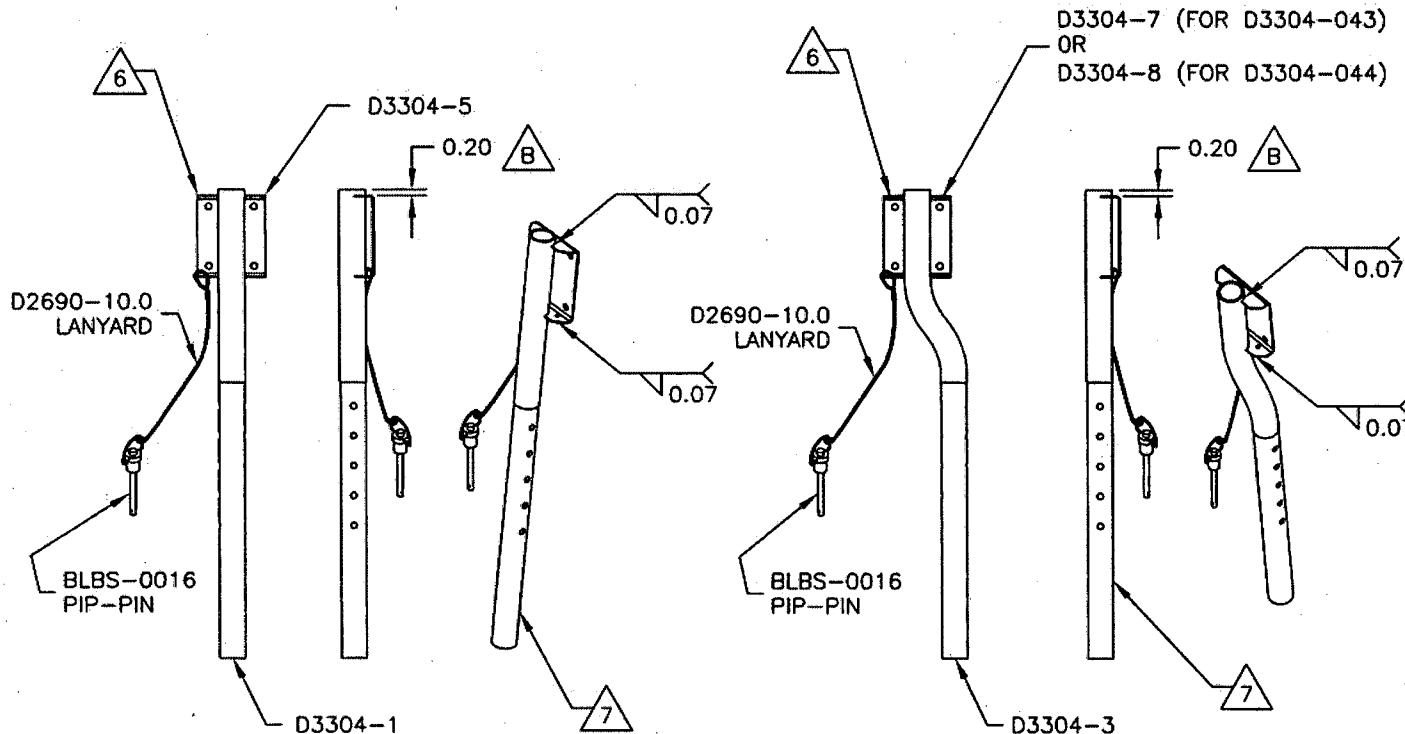
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**DART**

DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD	
CHECKED <i>H</i>	APPROVED <i>H</i>	DRAWING NO. D3304	HAWKESBURY, ONTARIO, CANADA REV. B
DATE 05.07.15		TITLE TUBE ASSEMBLY	SHEET 1 OF 4
A	04.08.18	NEW ISSUE	SCALE 1:6
B	05.07.15	UPDATE DIMENSIONS; ADD D3304-7/-8	

**D3304-041 TUBE ASSEMBLY****D3304-044 TUBE ASSEMBLY (SHOWN)  
D3304-043 OPPOSITE****RELEASED**  
5-08-11  
*M***D3304-041/-043/-044 NOTES:**

- 1) FINISH: POWDER COAT GREY SANTEX (REF. 4.3.5.6) PER DART QSI 005 4.3
- 2) WELD PER DART QSI 004
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 6) IDENTIFY AS INDICATED USING FINE POINT PERMANENT INK MARKER "TCCA-PDA, DART AEROSPACE LTD, P/N D3304-XXX B/N BXXXXX, FOR PRODUCT ELIGIBILITY SEE PDA04-11" IF BEING ASSEMBLED WITH D3303-041, ADD THE FOLLOWING USING A FINE POINT PERMANENT INK MARKER: "TCCA-PDA, DART AEROSPACE LTD, P/N D412-724-XXX B/N BXXXXX, FOR PRODUCT ELIGIBILITY SEE PDA04-11"

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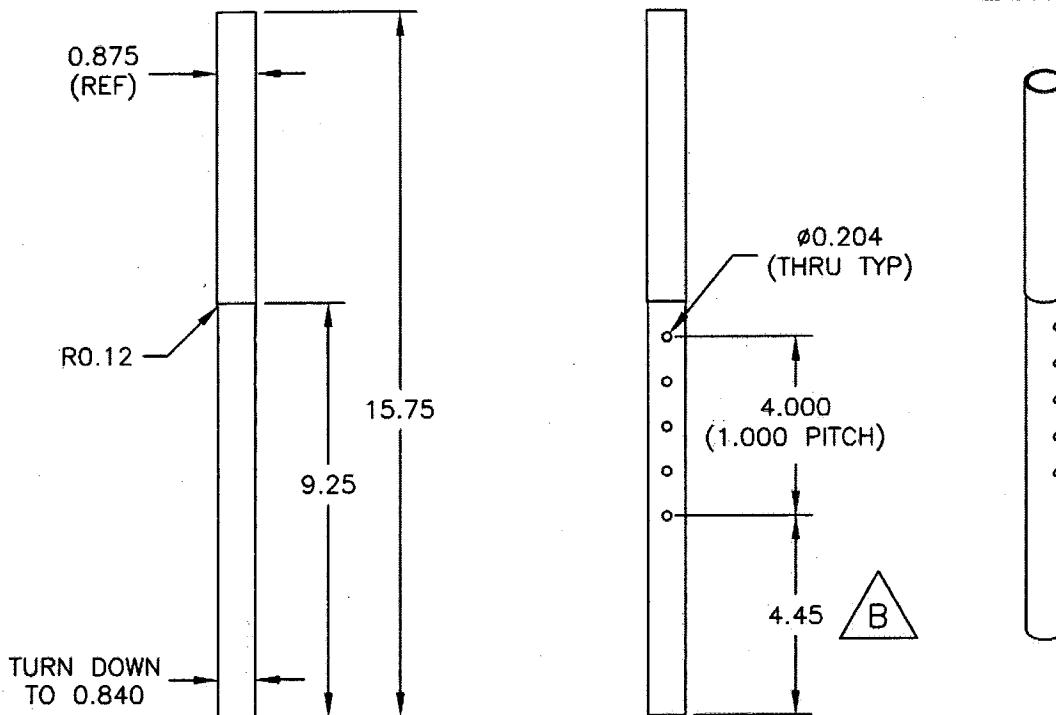
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NO. *140902*

WORK ORDER

**DART**

DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[initials]</i>	APPROVED <i>[initials]</i>	DRAWING NO. D3304	REV. B SHEET 2 OF 4
DATE 05.07.15		TITLE TUBE ASSEMBLY	SCALE 1:4

**RELEASED**  
05.08.11 #1**D3304-1 TUBE****D3304-1 NOTES:**

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL TUBE Ø0.875 x 0.065 WALL (REF. DART SPEC M304TR0.875W.065) ENSURE SEAMLESS TUBE IS USED
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.015

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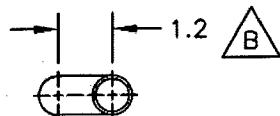
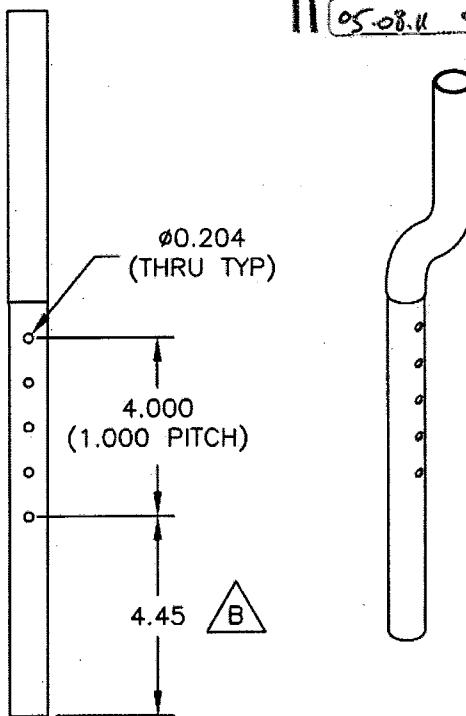
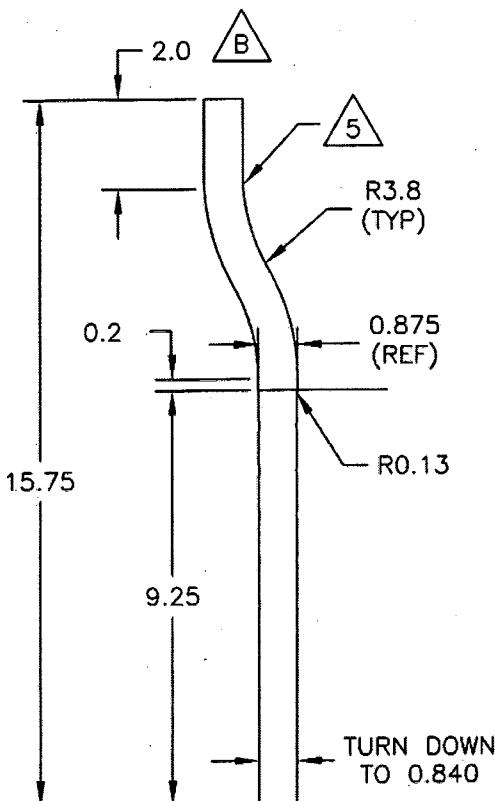
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WORK ORDER

NO. 40908

**DART**

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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3304	REV. B SHEET 3 OF 4
DATE 05.07.15		TITLE TUBE ASSEMBLY	SCALE 1:4

**D3304-3 TUBE****D3304-3 NOTES:**

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL TUBE  $\phi 0.875 \times 0.065$  WALL (REF. DART SPEC M304TR0.875W.065) ENSURE SEAMLESS TUBE IS USED
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 5) BEND LINES 9.625, 13.375 DIMENSIONS

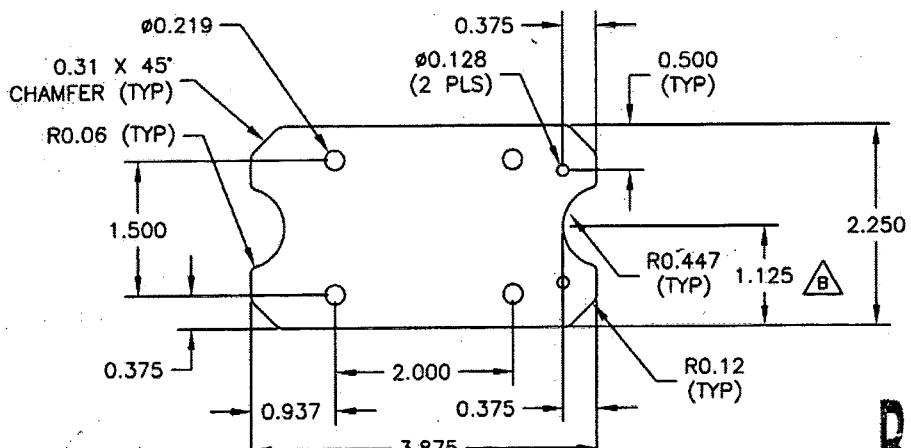
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NO. 40908

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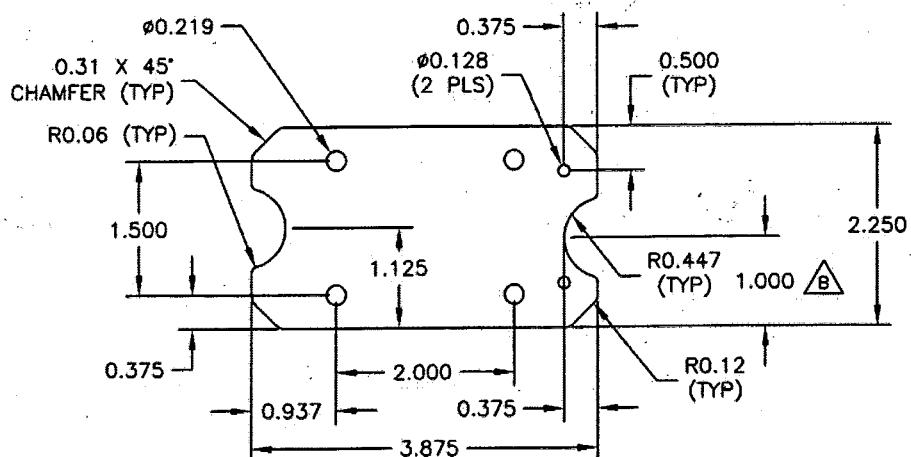
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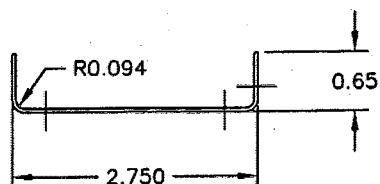
DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED 	APPROVED 	DRAWING NO. D3304	REV. B SHEET 4 OF 4
DATE 05.07.15	TITLE TUBE ASSEMBLY	SCALE 1:2	



**D3304-5 FLAT PATTERN**



**D3304-7/-8 FLAT PATTERN**



**D3304-5/-7 BRACKET  
D3304-8 OPPOSITE**

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WORK ORDER  
NO 40908

**NOTES:**

NOTE:

- 1) MATERIAL: AISI 304/316 SS 0.040 THICK SHEET (REF. DART SPEC M304S20GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.015

DART AEROSPACE LTD	Work Order:	40908
Description: BRACKET	Part Number:	U3304-8
Inspection Dwg: U3304-8 Rev: B		Page 1 of 1

# **FIRST ARTICLE INSPECTION CHECKLIST**

## X First Article      Prototype

Measured by:	HB	Audited by:		Prototype Approval:	n
Date:	8-8-08	Date:	08/08/08	Date:	7

<b>Rev</b>	<b>Date</b>	<b>Change</b>	<b>Revised by</b>	<b>Approved</b>
A		New Issue	KJ/JLM	